

Date: Monday, 25/09/2006 11:09:41 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL
Job Number : 28625	
Estimate Number : 10906	
P.O. Number : N/A	Part Number : D33303
This Issue : 25/09/2006 S.O. No. : N/A	Drawing Number : D3330 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B1
Previous Run : 28625	Material : N/A
Written By : _____	Due Date : 05/10/2006 Qty: 8 Um: Each
Checked & Approved By : _____	
Comment : Est. A05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1010S125	1010-1025 sheet .125
-----	-----------	----------------------



Comment: Qty.: 0.7130 sf(s)/Unit Total : 5.7036 sf(s)
 1010-1025 sheet .125
 Batch: M102247 M1 06 10 03

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3330
 Dwg Rev: B1
 Prog Rev: B1

M1 06 10 03

⑧

2-Deburr if necessary

cmf. 06/10/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M1 06 10 04

⑧

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

06.10.05 ⑧

B7C

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr
 Form as per Dwg D3330

N/A 06.10.25

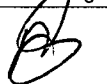

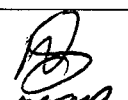

06.10.07 ⑧

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-04	20	1 hole deviates from Dwg. AS shown. Also Dwg states $\phi.250 \times 4$, but is $\phi.250 \times 5$ holes		Modify DXF for water jet to correct holes to dwg, and clarify hole size: Qty. Holes are drain holes, part acceptable.		 06-10-05		 06-10-04

NOTE: Date & initial all entries

Date: Monday, 25/09/2006 11:09:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 28625

Part Number: D33303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



N/A 06/10/25



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W523

PPL 06-10-26

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

06/10/26

Job Completion



W 06/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 12:03:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 28625		
Estimate Number	: 10906		
P.O. Number	:	Part Number	: D33303
This Issue	: 9/15/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3330 REV B1
First Issue	: //	Project Number	: N/A
Previous Run	:	Drawing Revision	: B1
	Type : PURCHASED PARTS	Material	:
Written By	: <u> </u>	Due Date	: 10/5/2006
Checked & Approved By	: <u> </u>	Qty:	8 Um: Each
Comment	: Est. A05.01.15 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: _____
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3330
 Possible Supplier: Industrial Laser
 Material release note is required

6795F
 11/01/05/125

W2 for jet

2.0

D33303F

Panel

**Comment:** Qty.: 1.0000 U(s)/Unit Total : 8.0000 U(s)

Panel

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3330 , or D3330-3 T1 Template

5.0

BRAKE NC

NC BRAKE

**Comment:** NC BRAKE

Deburr
 Form as per Dwg D3330

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 12:03:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 28625

Part Number: D33303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

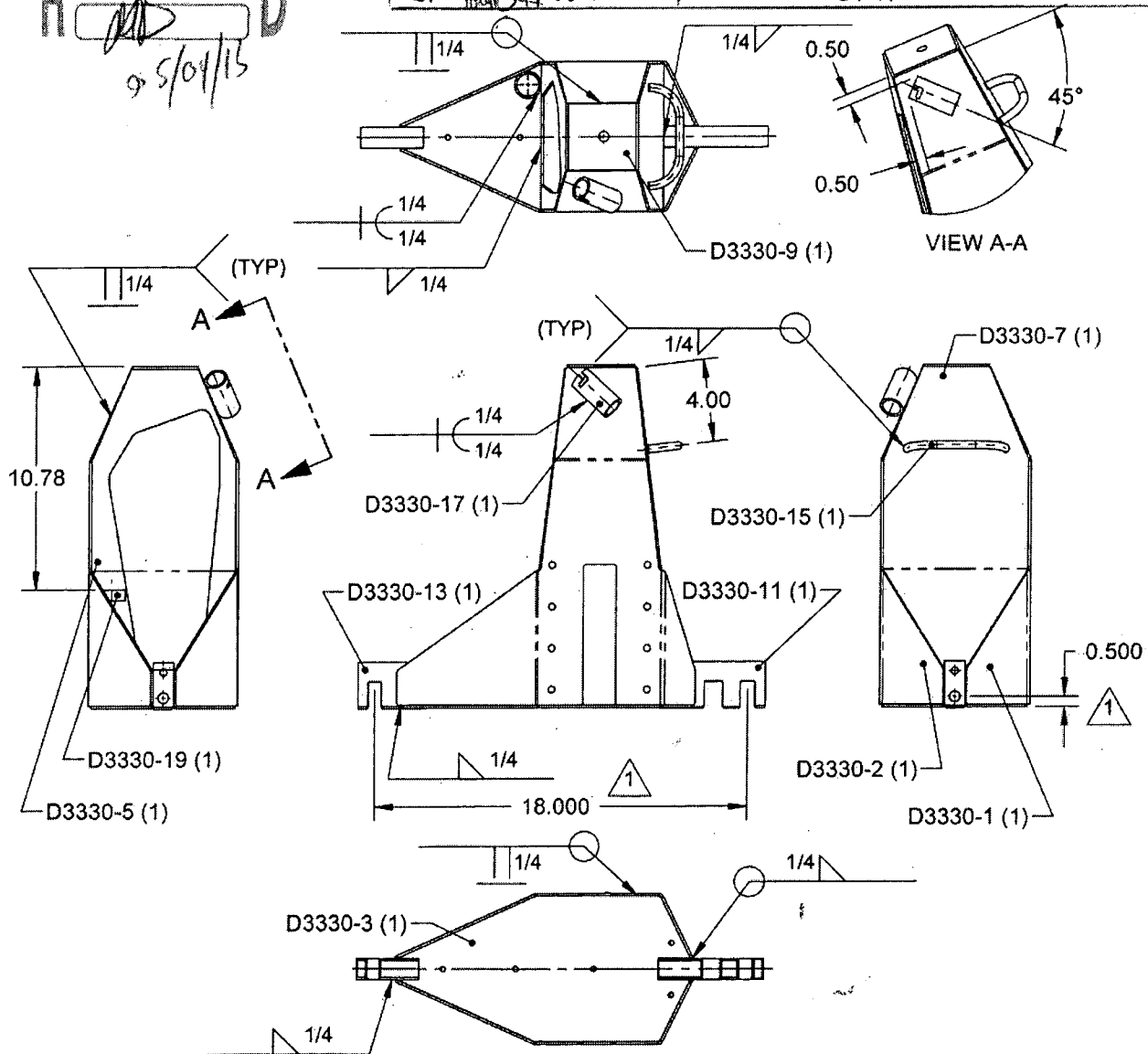
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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9/5/04/15

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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	
BI	05.07.04	ADD 1.605 DIM.	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. **28625**

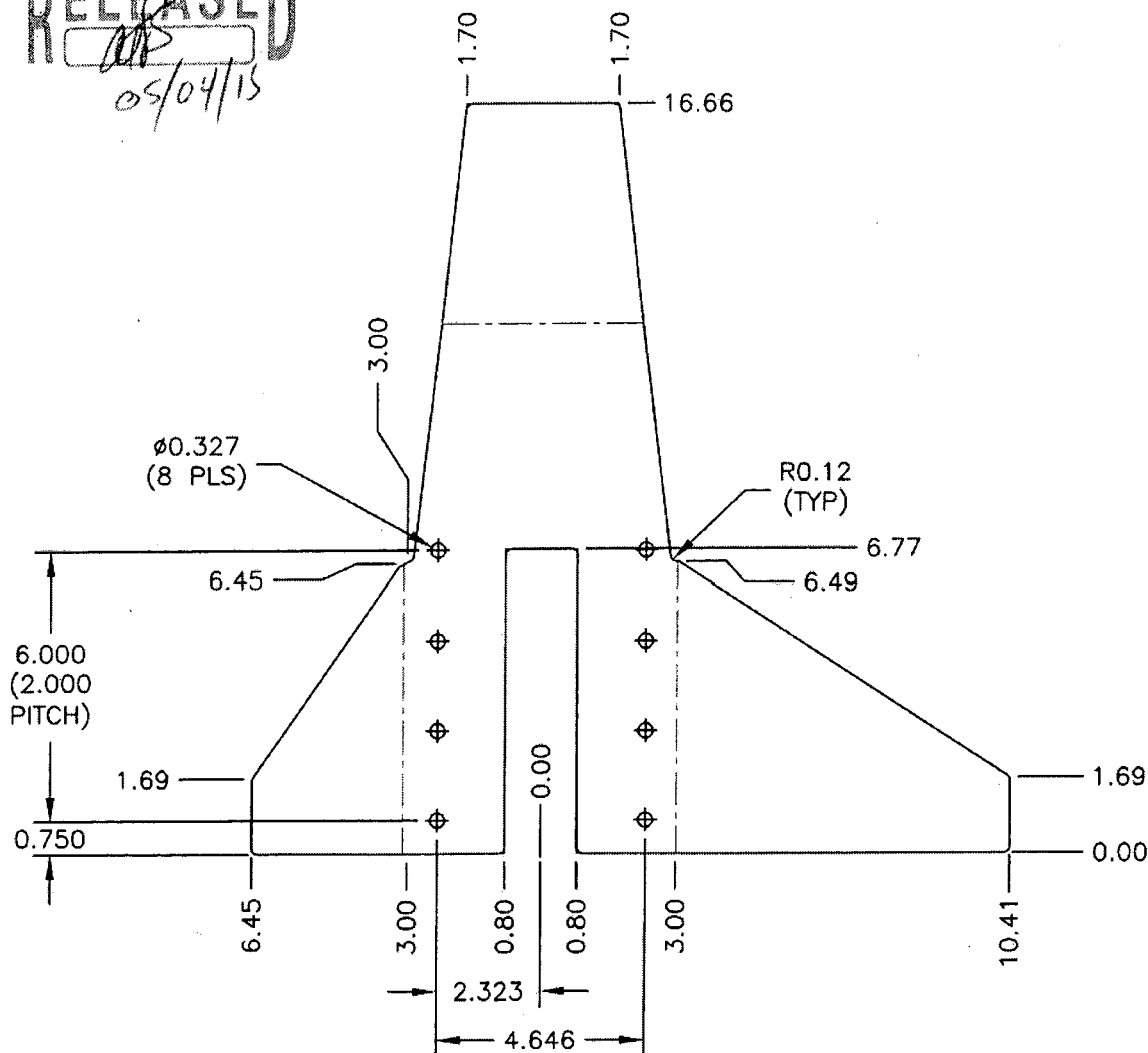
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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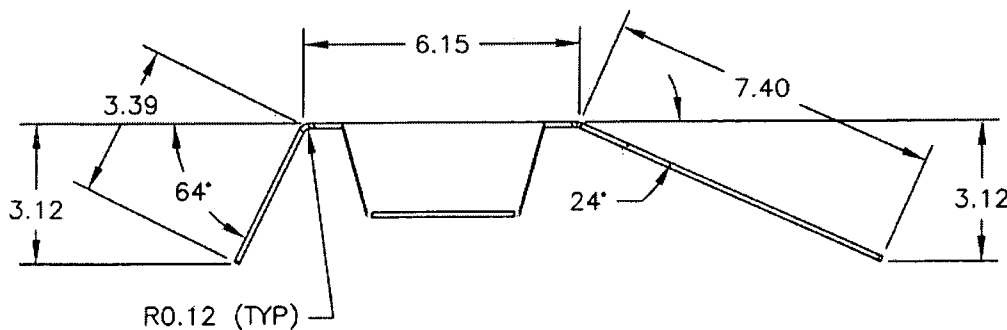
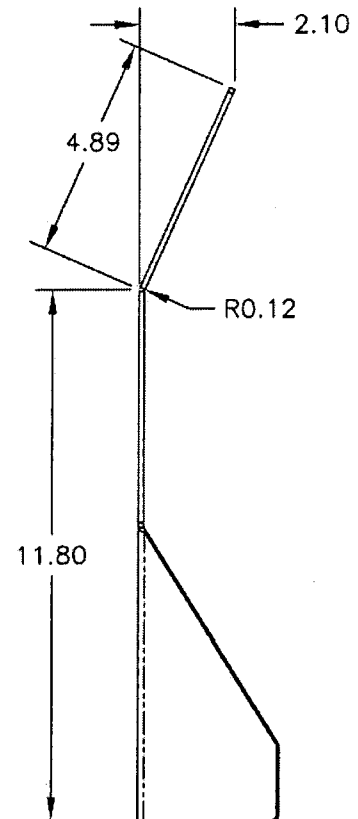
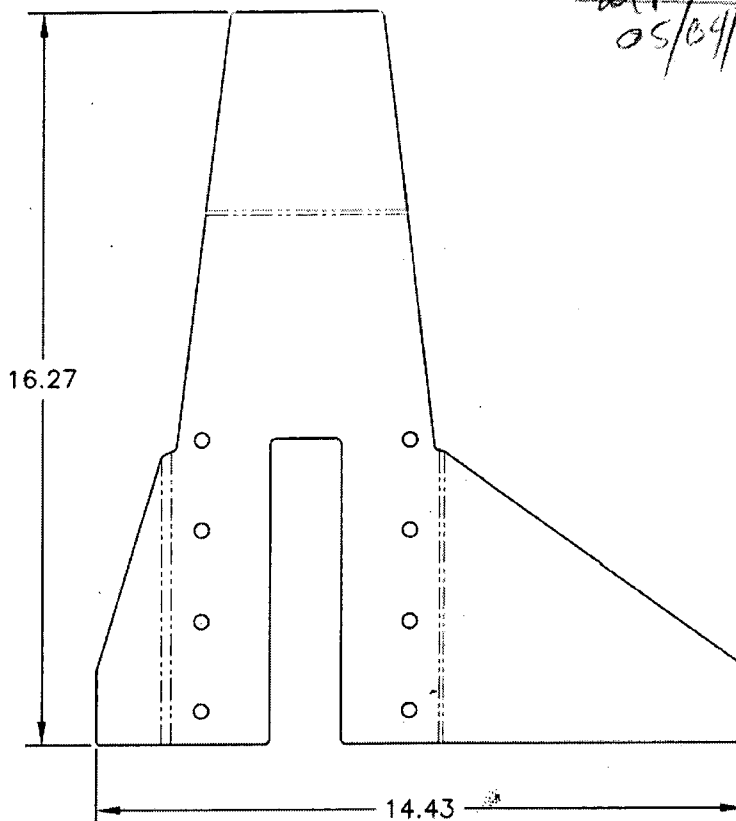
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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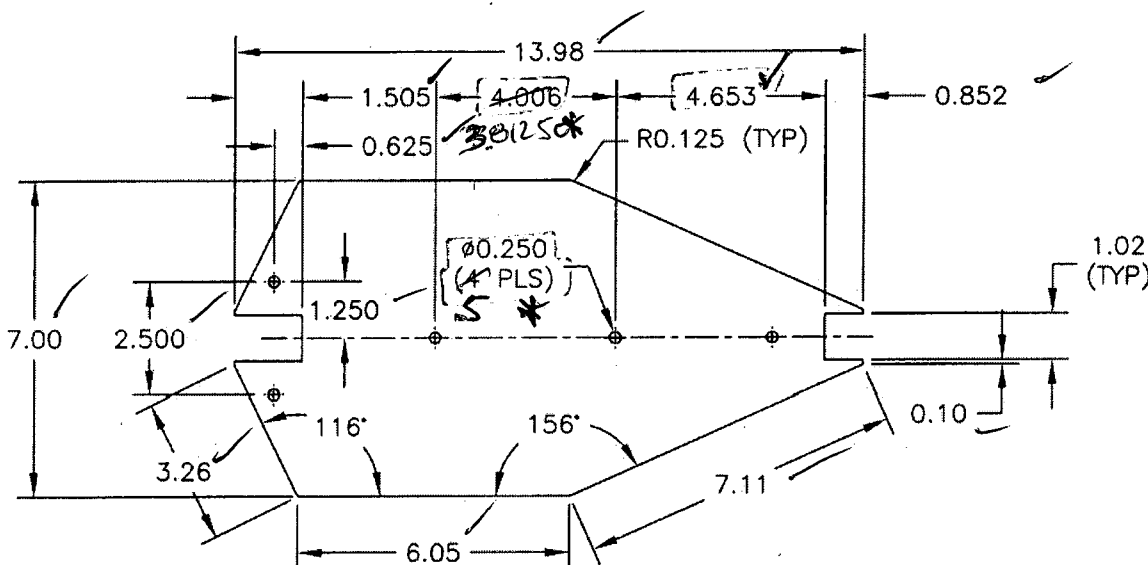


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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED

05/04/15

* 06.10.05
DRAWING MOVED



D3330-3 PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-02, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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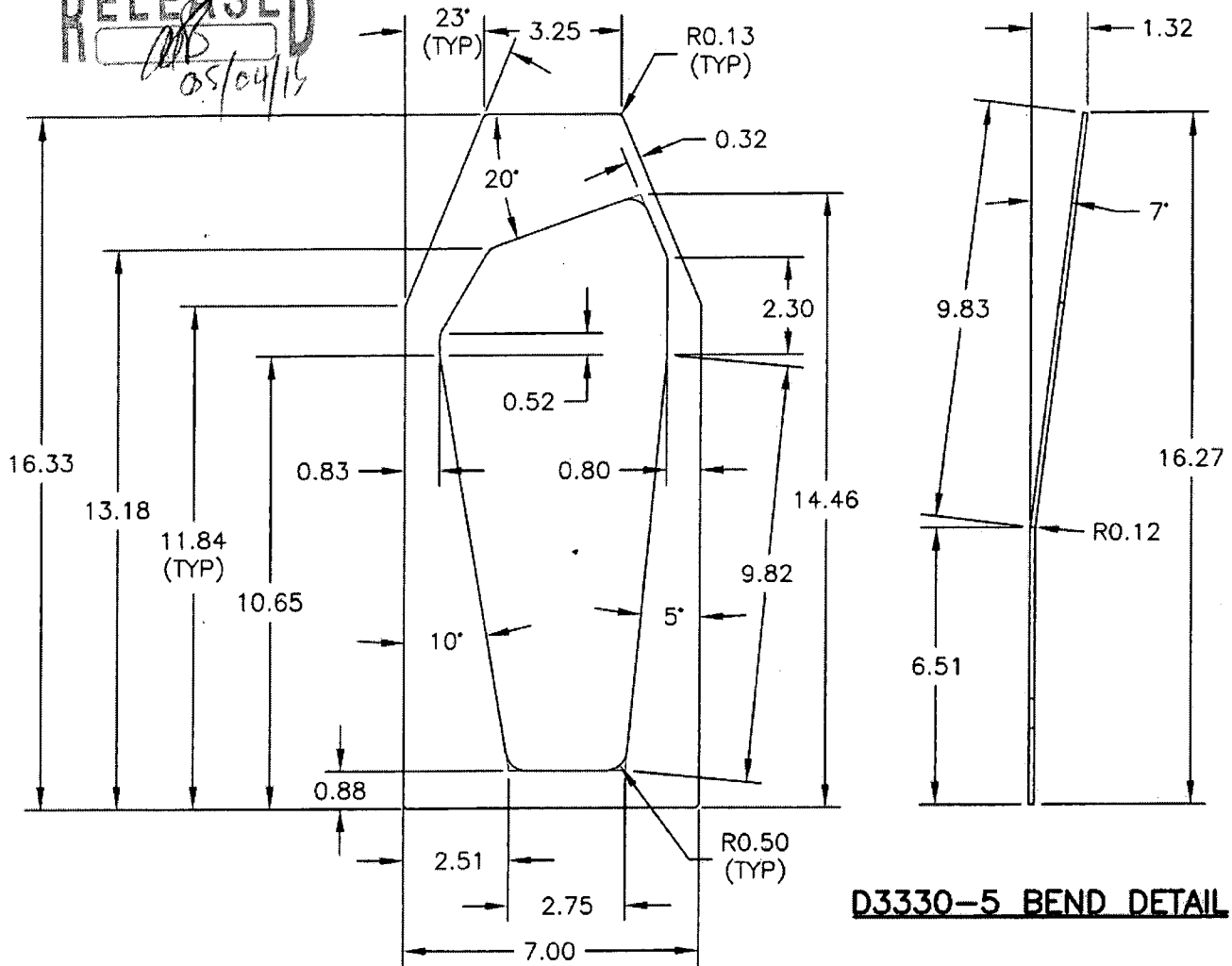
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:4

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05/04/16



D3330-5 BEND DETAIL

FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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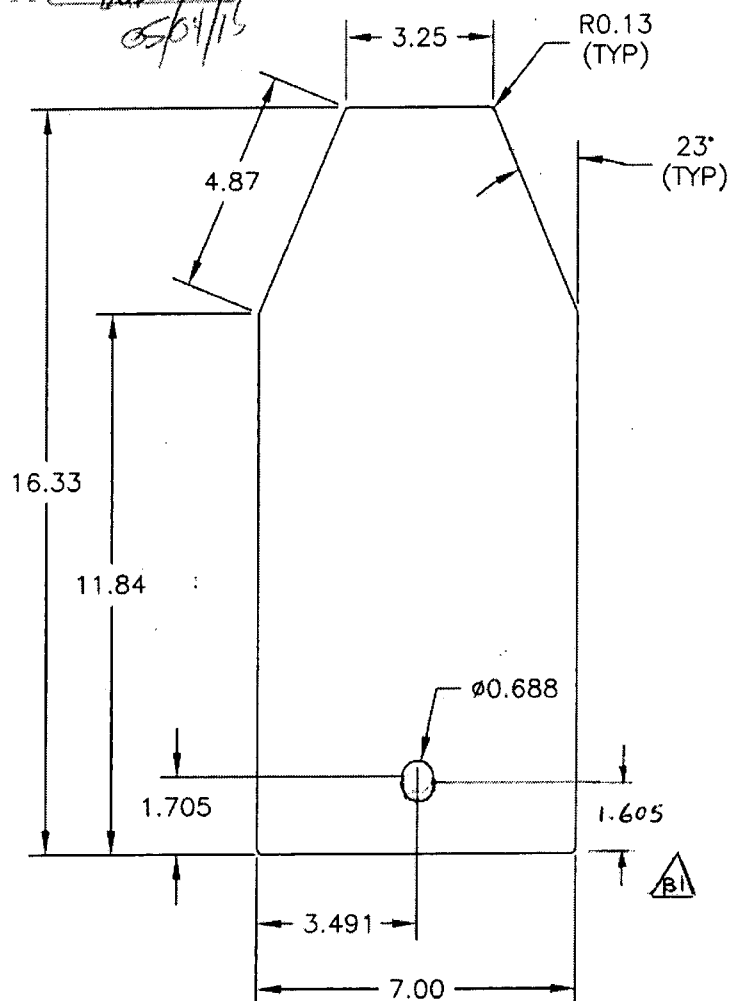
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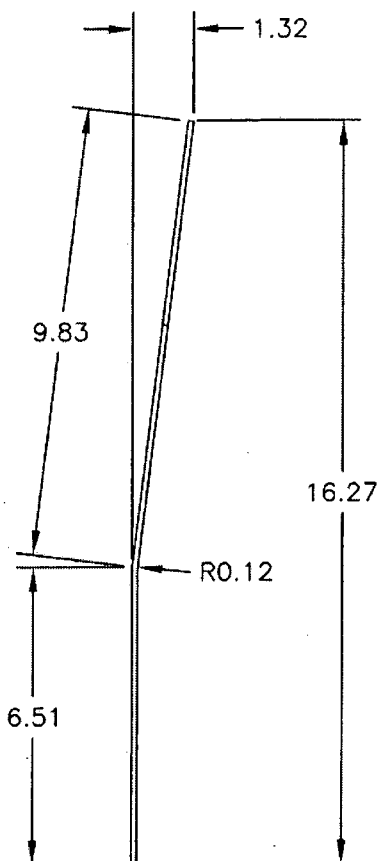


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DATE 05.02.26		TITLE FRAME ASSEMBLY	SCALE 1:4

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05/11/15



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

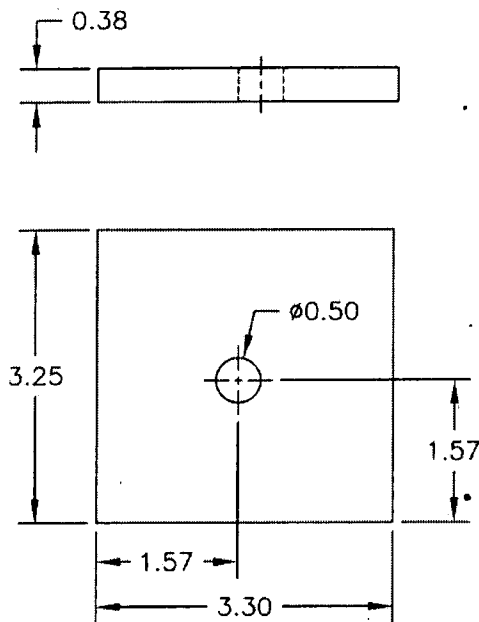
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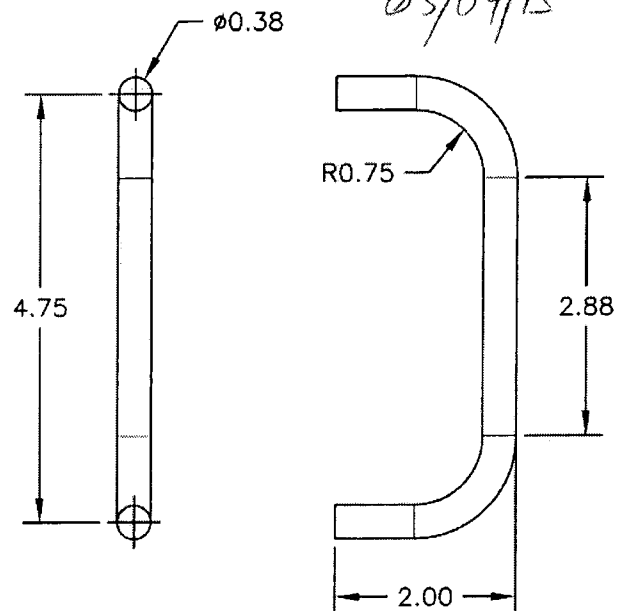
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:2



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

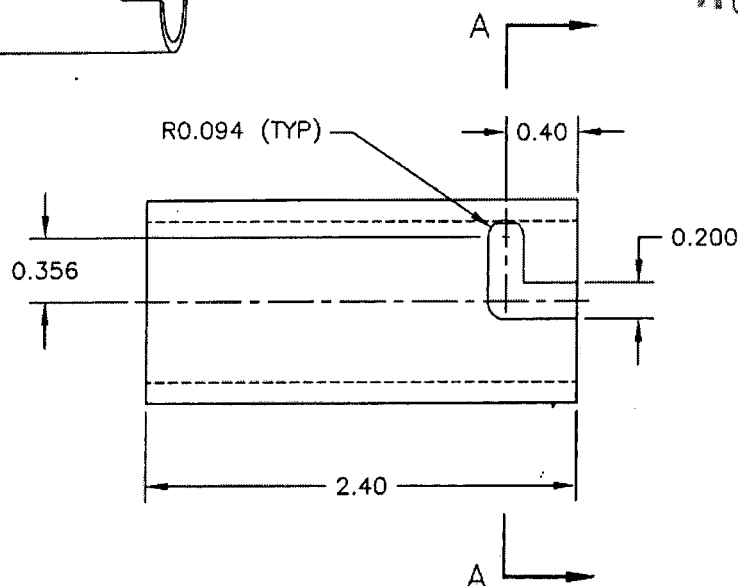
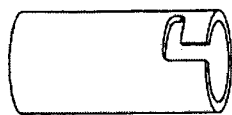
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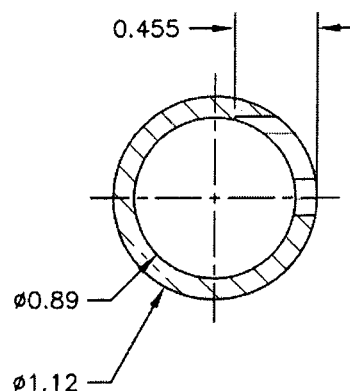
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:1

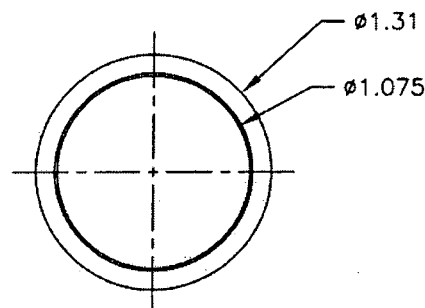
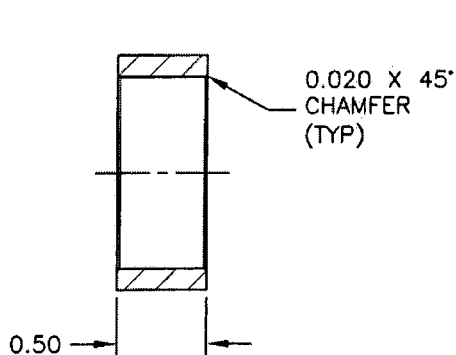


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05/04/15



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

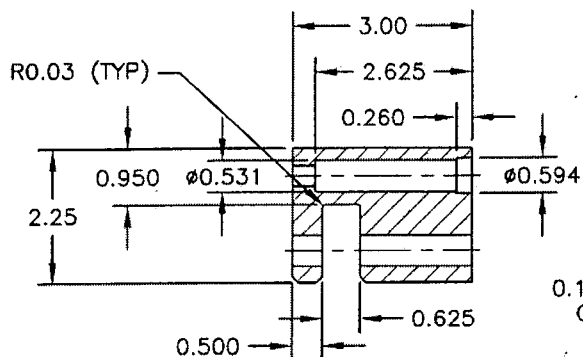
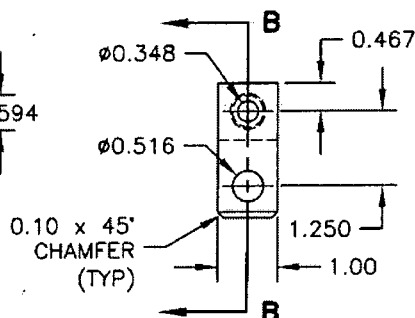
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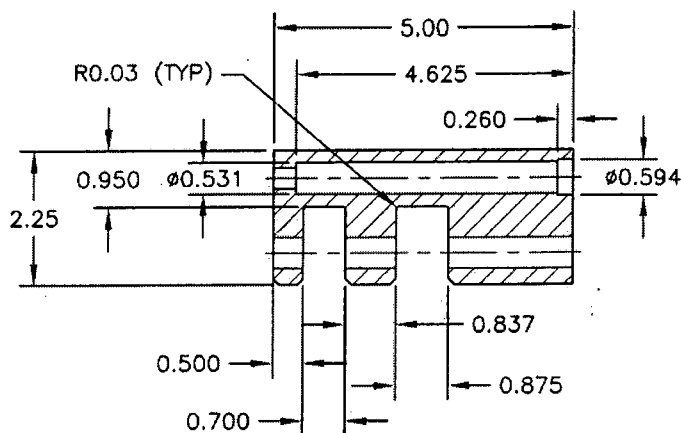
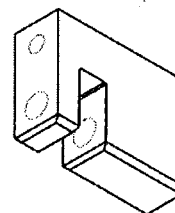
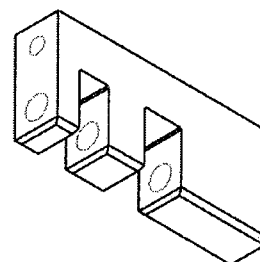
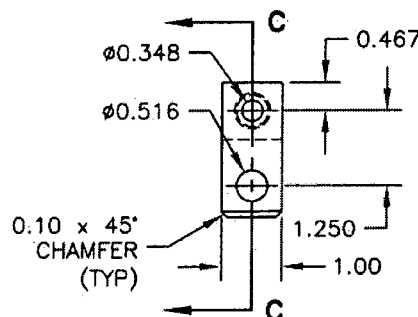
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET**

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[Signature]
05/04/15

**SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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